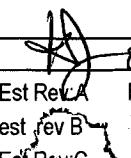
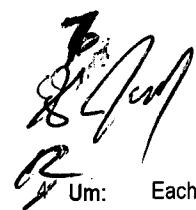


Friday, 7/4/2008 12:50:05 PM  
Kim Johnston

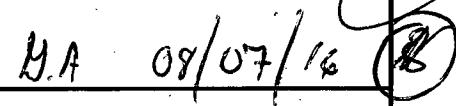
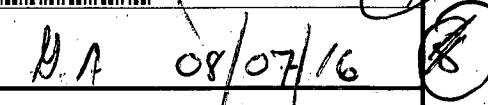
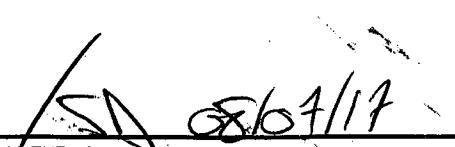
## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	ARM
Job Number	40299				
Estimate Number	12578				
P.O. Number				Part Number	D3560041
This Issue	7/4/2008	S.O. No.		Drawing Number	D3560 REV D
Prsht Rev.	NC			Project Number	N/A
First Issue	/ /	Type	MACHINED PARTS	Drawing Revision	D
Previous Run	35403			Material	
Written By	 08/07/07			Due Date	7/14/2008
Checked & Approved By				Qty:	 B Um: Each
Comment	Est Rev A	New Issue	07.05.24	EC	
	est rev B	ECN 987	07.10.09	EC verified by: DD	
	Esf Rev:C	ECN1048	07-12-18	DD verified by: EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"	
		Comment: Qty.: 1.4648 f(s)/Unit Total : 5.8590 f(s) 6061-T6 Bar 0.50" x 5.0" Batch: M108586	 M.A 08/07/16
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 16.750" long	 M.A 08/07/16
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1  1- Mill as per Folio FA693 Rev: <u>B</u> & Dwg D3560 Rev: <u>D</u>  2-C'sink 0.196" hole on manual mill as per dwg D3560  3-Deburr per dwg D3560	 M.A 08/07/17
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 M.A 08/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:50:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 40299		Part Number: D3560041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	D35921	Plate SP 08-08-27
Comment: SECOND CHECK		
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 SP 08-08-27
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		
STEP:		
1- clean material (buff bracket and bottom of arm with blue pad) SP		
2- set up bracket and arm on jig SP		
3- preheat bracket and arm with torch SP		
4- clean before welding with brush SP		
5- set up machine to 135 amps SP		
6- weld across bottom and top ends SP		
7- reheat with torch ( 65 deg C ) SP		
8- on one side weld from bottom to top half way SP		
9- same for other side (half way) SP		
10- from half way point weld the rest of the first side (ease off pedal near end) SP		
11- same for remaining side (ease off pedal near end) SP		
8.0	QC5	INSPECT WORK TO CURRENT STEP SP 08-08-29
Comment: INSPECT WORK TO CURRENT STEP 08/08/29 X7		
9.0	QC9	VISUAL WELDING INSPECTION PD 08-08-29 (1)
Comment: VISUAL WELDING INSPECTION		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:50:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 40299

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*MM 08/08/08*

*(X)*

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-08-08 XZ*

12.0 D2808 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

batch: *B37113*

*08/09/08*

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

*08/08/08 (X)*

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/09/08 (X)*

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 152*

*AS 08/09/03 (X)*

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/03 (X)*

Job Completion



*MF 08-09-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40299
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560	Rev: B D 66.07.07	Page 1 of 1

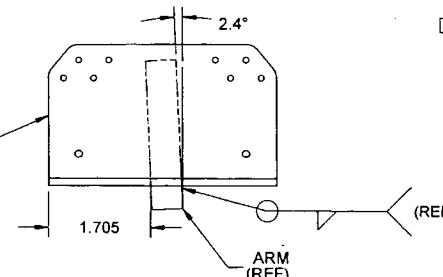
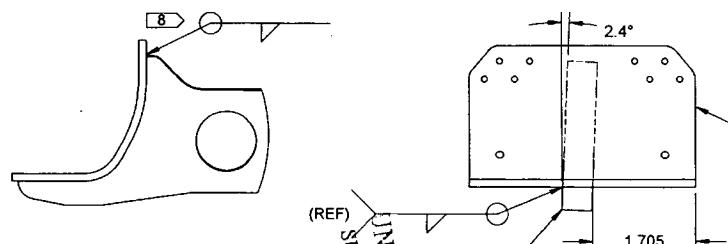
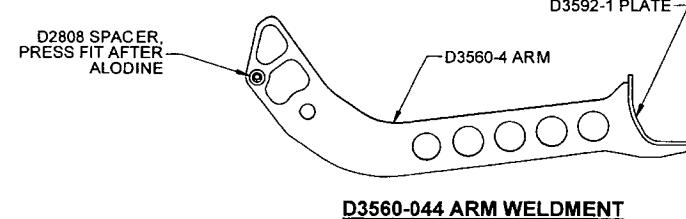
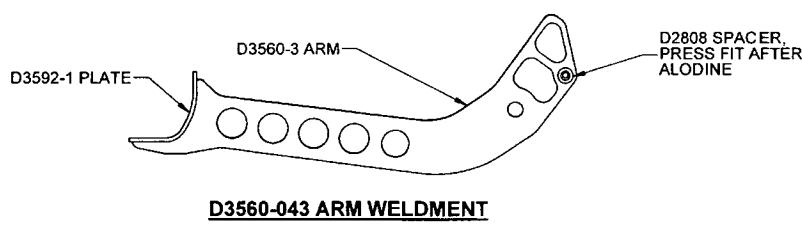
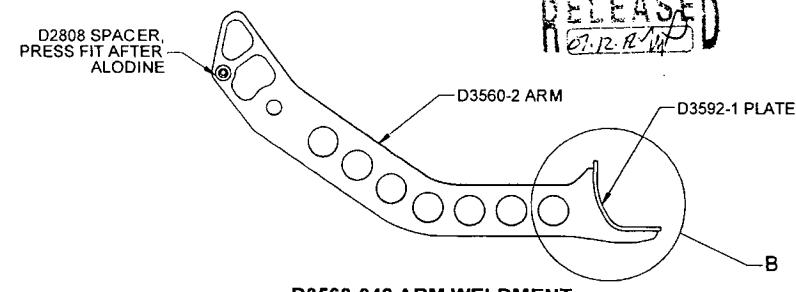
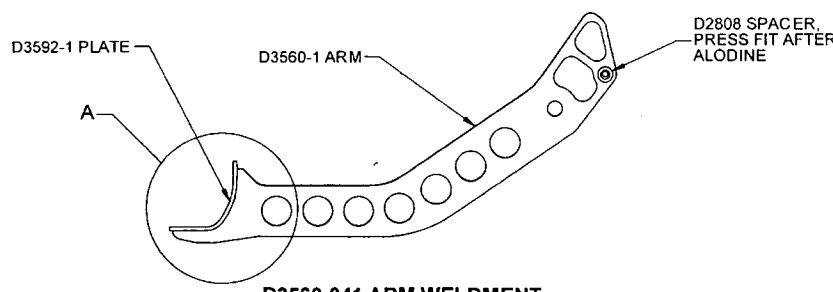
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>SJ / Y.A</u>	Audited by:	<u>S.J.</u>	Prototype Approval:	N/A
Date:	<u>08/07/17</u>	Date:	<u>08/07/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	E

RELEASED  
07-12-11 14



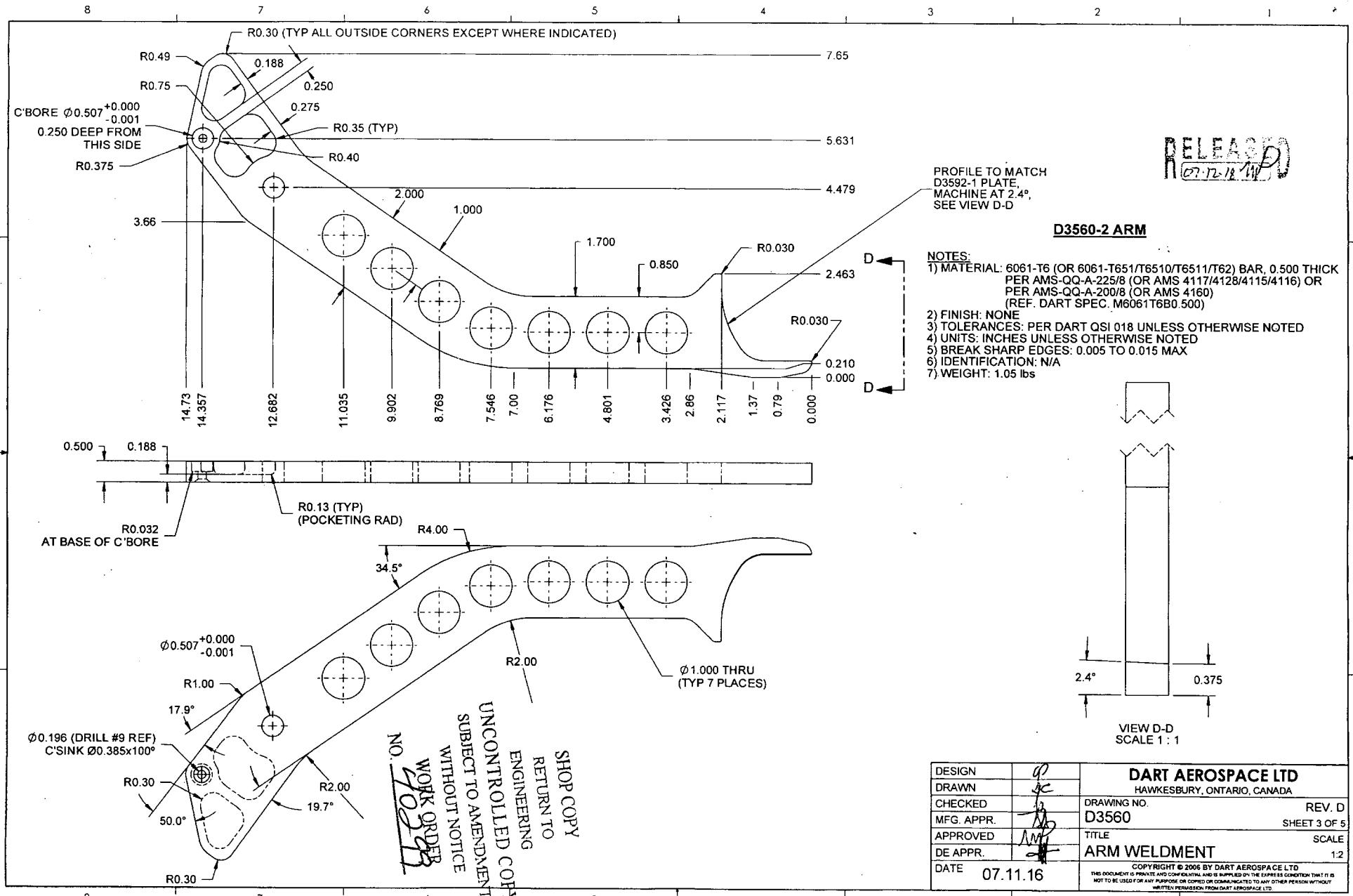
PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>19</i>	DART AEROSPACE LTD	
DRAWN	<i>JFC</i>	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>SJ</i>	DRAWING NO.	D3560
MFG. APPR.	<i>EJ</i>	REV. D	SHEET 1 OF 5
APPROVED	<i>WV</i>	TITLE	ARM WELDMENT
DE APPR.	<i>WV</i>	SCALE	14
DATE	07.11.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NOTES:  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.23 lbs (TYP)  
8) WELDING: PER DART QSI 004

NO.  
WORK ORDER  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY



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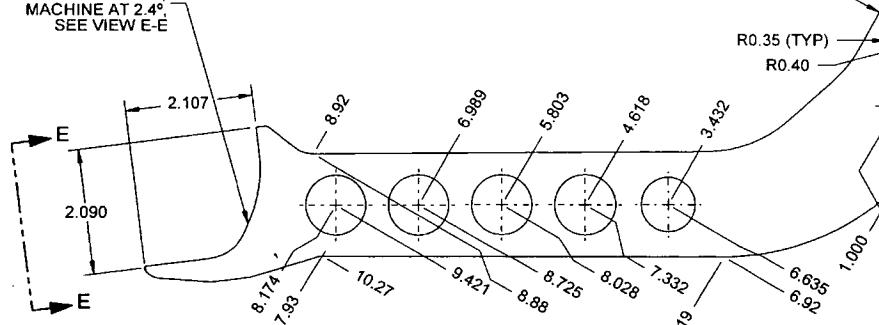
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D

PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



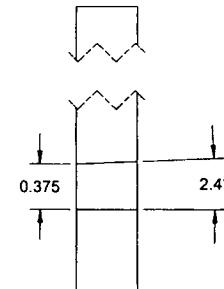
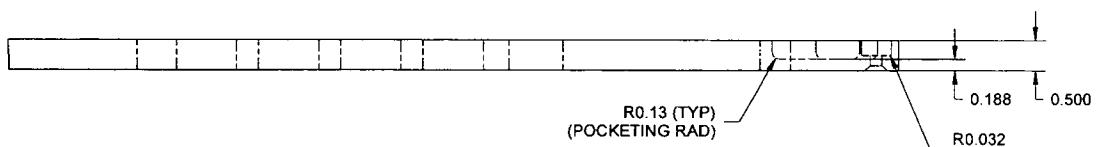
### D3560-3 ARM

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

C

C

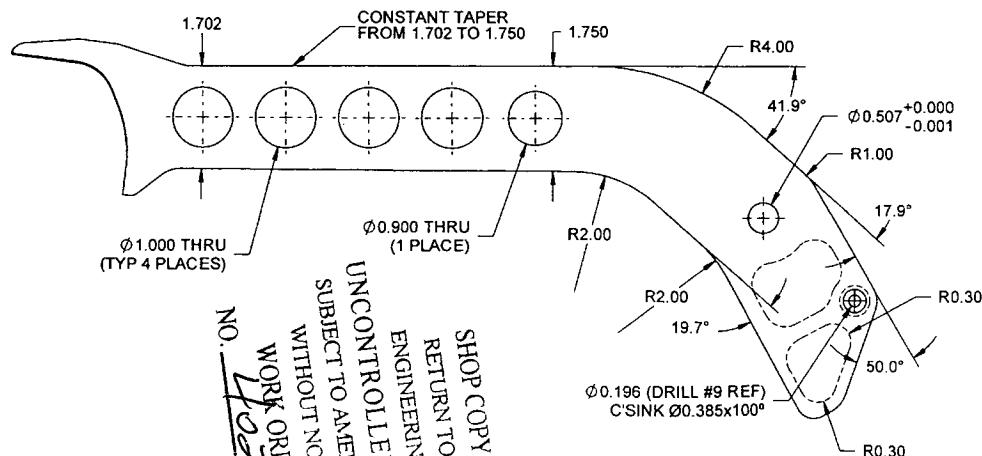


VIEW E-E  
SCALE 1:1

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RETURN TO  
SHOP COPY

DESIGN	<u>9</u>	DART AEROSPACE LTD	
DRAWN	<u>4C</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u> </u>	DRAWING NO.	
MFG. APPR.	<u> </u>	D3560	REV. D
APPROVED	<u> </u>	TITLE	SHEET 4 OF 5
DE APPR.	<u> </u>	ARM WELDMENT	SCALE
DATE	07.11.16		1:2

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